

5/03

DART AEROSPACE LTD	Work Order:	22050
Description: Fitting	Part Number:	D3299-3
Dwg: D3299 Rev. A <i>11.11.16</i>	Qty:	409
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>JA</i>	04.12.08	109
2	MC	Machine as per Folio FA452 and Dwg D3299 Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.00" Hex (M6061T6H1.000) Identify as D3299-3 Batch: <i>179075</i> 179075	<i>TML</i>	05/01/07	109
3	QC2	Inspect parts as they come off the CNC machine	<i>TML</i>	05/01/07	109
4	QC8	Second check	<i>FE</i>	05.01.10	9
5	MC	Deburr	<i>TML</i>	05/01/10	9
6	PG	Issue P/O: <u>2007621</u> Anodize as per Dwg D3299 Possible Supplier: TNM Paint Material release note is required	<i>ed</i>	05/01/10	9
7	RG	Receive and Inspect for transit damage Ensure material release note is attached	<i>CL</i>	05/02/08	9
8	QC5	Inspect work to Step 7	<i>2</i>	05-03-01	9
9	ST	Identify and Stock <i>Identify with Part # Batch # with a FINE Point Marker</i>	<i>CL</i>	05/03/02	9
10	AC	Cost / part: <u>27.81</u>	<i>545</i>	05.03.03	9
11	DC	Close W/O <u>27.81</u> Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	04.10.04	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
[Signature] 04.10.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.01.10	2	1 scrap, thread off by 1.3°						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22050
Description: Fitting		Part Number:	D3299-3
Inspection Dwg: D3299	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.001	✓		Vern	
Ø0.302	+0.005/-0.000	Ø0.306	✓		Vern	
0.550	+/-0.010	0.544	✓		Vern	
0.63	+/-0.030	0.641	✓		Vern	
2.08	+/-0.030	2.085	✓		Vern	
0.900		0.906	✓		Vern	
53°		52°	✓		Protractor	
0.476	+0.005/-0.000 +0.001/-0.005 check dwg	0.475	—		Vern	
MOW for 9/16"-18	Min = 0.5653 Max = 0.573	0.571	✓		Micro	
0.200	+/-0.030	0.190	✓		Vern	
0.450	+/-0.010	0.450	✓		Vern	
0.10	+/-0.030	0.091	✓		Vern	
Length of Engagement for 1/4 NPT 0.227	+/-0.010	0.327	✓		Vern	

Measured by:	<i>ML</i>	Audited by:	<i>EE</i>	Prototype Approval:	N/A
Date:	08/01/07	Date:	05.01.10	Date:	N/A

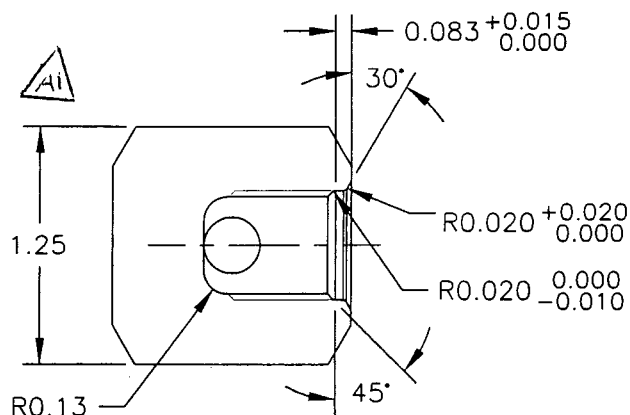
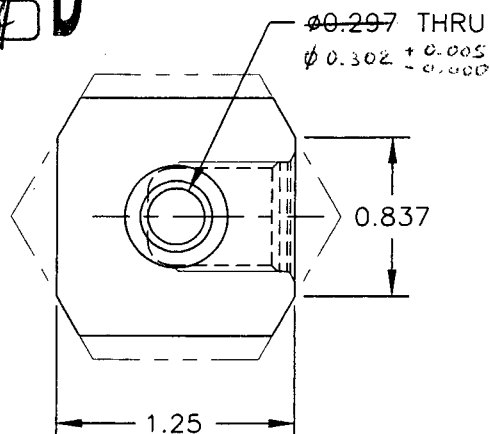
Rev	Date	Change	Revised by	Approved
A	04.09.17	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED
[Signature]

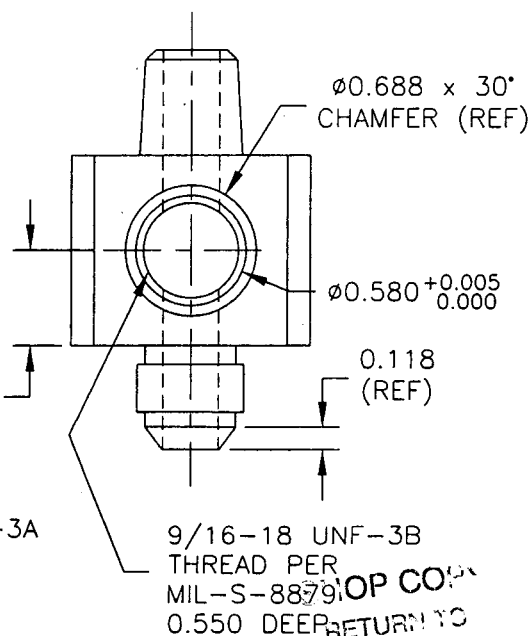
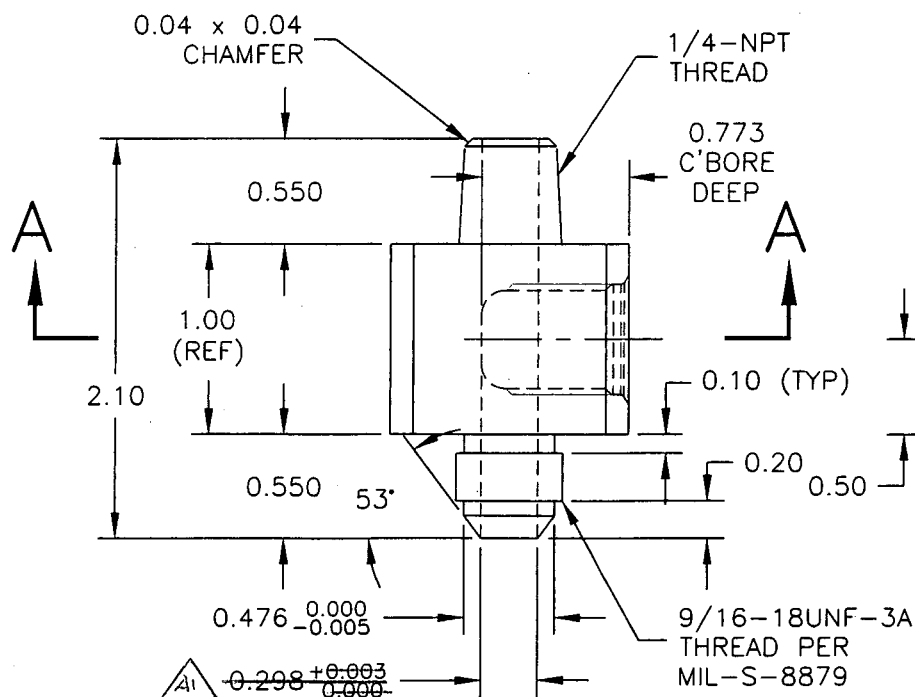


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3299	REV. A SHEET 1 OF 3
DATE 04.07.06	TITLE FITTING	SCALE 1:1	
A	04.07.06	NEW ISSUE	
A1	<i>[Signature]</i> 04.11.15	Ø0.302 WAS Ø0.297; ADD Ø0.540; R0.13	

RELEASED
04.09.09 *[Signature]*



SECTION A-A



D3299-1

D3299-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR III, CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER





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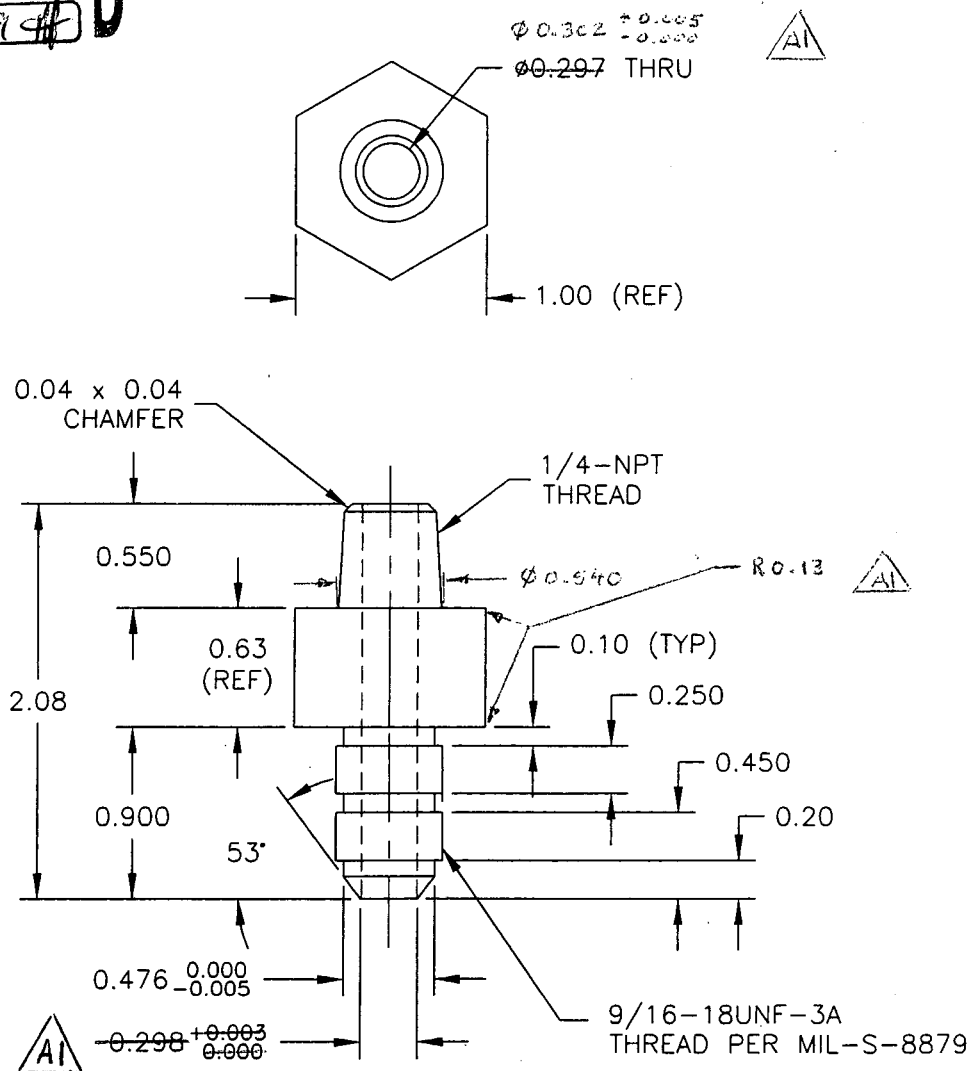
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NO. 22050



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CHECKED 	APPROVED 	DRAWING NO. D3299	REV. A SHEET 2 OF 3
DATE 04.07.06		TITLE FITTING	SCALE 1:1

RELEASED
04.09.09



D3299-3

D3299-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1000)
2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
3) BREAK ALL SHARP EDGES 0.005 TO 0.010
4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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ENGINEERING
06116HIT0000) COPY
HB CLASS 2
SUBJ: EN

WORK ORDER
NO. 22050

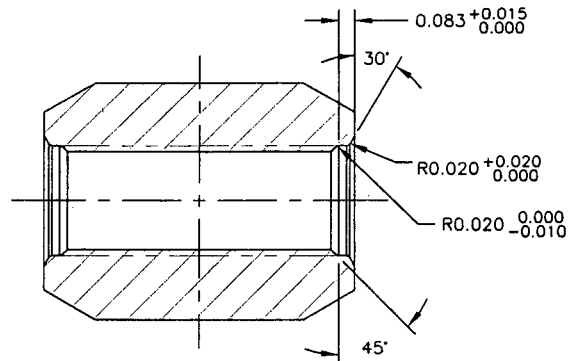
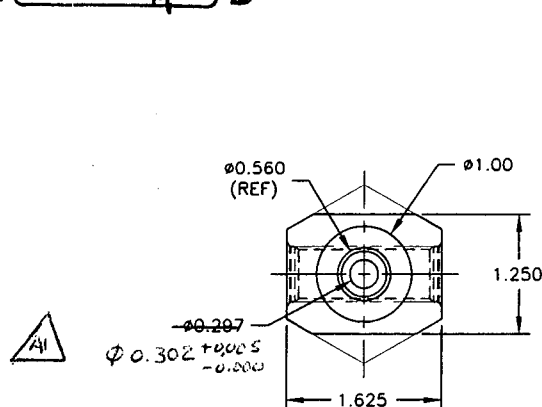
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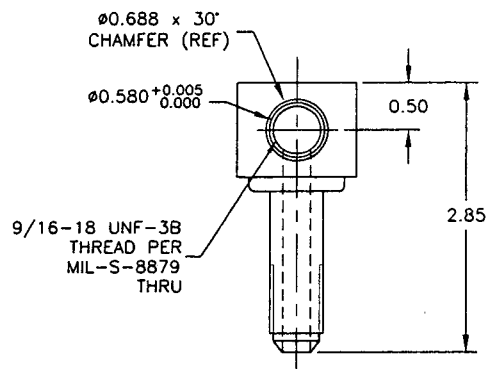
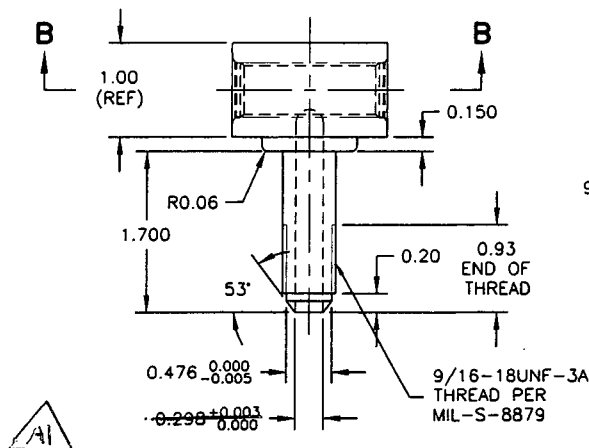


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3299	REV. A SHEET 3 OF 3
DATE 04.07.06	TITLE FITTING		SCALE 1:2

RELEASED
04.04.06 [Signature]



SECTION B-B
SCALE 1:1



D3299-5

D3299-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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NO. 22050

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 06, 2004
11:09 am

Work Order No : 0022050
Project Name : D3299-3
Project For : WK503
Work Order Type : Main
Main WO Number :
House Part Number : D3299-3
Description : Fitting
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 12-03-04
Est Finish Date : 01-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

TNM**ANODISATION et PEINTURE TNM INC.**

C. OF C

4454 Garand, Ville St. Laurent, QC H4R 2A2
Telephone: (514) 335-7001 Fax: (514) 335-3920
Certifié ISO 9001-2000 / ISO 9001-2000 certified
Certifié NADCAP / NADCAP certified

39237

25-Feb-2005

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE****PURCHASE ORDER/
NO. DE COMMANDE: 2007621**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION		PART PROCESS & TREATMENT
1	9	9	D3299-1	B22049	DESC: FITTING BLUE ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER
2	9	9	D3299-3	B22050	DESC: FITTING BLUE ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER
3	6	6	D3299-5	B22051	DESC: FITTING BLUE ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER

Nous certifions que les articles énumérés ont été procédés accordément à l'inspection ci-haut.
Les cartes de travail ont été remplies et sont disponibles pour consultation sur demande.

We hereby certify that the above parts have been processed in accordance with the above inspection.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: _____

Directeur de la Qualité / Q.A. Manager